User: Job Number This Issue Prsht Rev. First Issue **Previous Run** Written By

Thursday, 01/05/2008 10:46:55 AM

Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

: 38935

Estimate Number

: 11167

P.O. Number

: 01/05/2008

: NC

: //

: 35312

Type

S.O. No. :

: SMALL /MED FAB

Part Number Drawing Number Project Number

Drawing Name

: D3278 REV C : N/A

: SPACER

: D32783

: C

Drawing Revision Material

: 08/05/2008 **Due Date**

Qty:

100 Um:

Each

Checked & Approved By

Comment

04.04.19 New issue KJ/JLM

B 07.09.06 Rev C dwg EC Verified by: JLM Est

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

Black Delrin Sheet .125

1.0

2.0

MDELRINS0125







Comment: Qty.:

0.0361 sf(s)/Unit Total:

3.6120 sf(s)

Black Delrin

Material: Black Delrin/UHMW 0.125" thick

(M-DELRIN-S0.125x30.0) Identify for D3278-3, w14348

Batch:



Comment: FLOW WATER JET

1-Cut as per Dwg D3278

Dwg Rev:

Prog Rev:_

1B8-5-2

2-Deburr if necessary

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



1B 8-5-2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

Page 1

Dart Aerospace Ltd

Duitho	oopaoo =	· ·							
W/O:			WORK ORDER	CHANGES					
DATE	STEP	PROCE	DURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							5		
			_						
Part No	·	PAR #:	Fault Category:	NCR	∷ Yes	No DQ	\ \ :	Date:	
								Date:	
NCR:		WO	RK ORDER NON-CON	FORMANCE	(NCF	R)			
		Description of NC	Corrective Action	n Section B		Verific	ation	Approval	Approval

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC Corrective Action Section B			Corrective Action Section B		Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector		

NOTE: Date & initial all entries

· Thursday, 01/05/2008 10:46:55 AM Data: User: Linda Lacelle **Process Sheet** Drawing Name: SPACER Customer: CU-DAR001 Dart Helicopters Services Job Number: 38935 Part Number: D32783 Job Number: Seq. #: Description: **Machine Or Operation:** SMALL & MEDIUM FAB RESOURCE 1 5.0 SMALL FAB 1 XIOS Comment: SMALL & MEDIUM FAB RESOURCE 1 1-C'sink as per dwg D3278 2-Deburr INSPECT WORK TO CURRENT STEP QC5 6.0 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 7.0 PACKAGING 1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 8.0 QC21 FINAL INSPECTION/W/O RELEASE Comment: FINAL INSPECTION/W/O RELEASE Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CH	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							1
Part No		PAR #: Fault Category:	NCR: Yes	No DQ	A:	_ Date: _	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Varification	Approval Chief Eng	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C		Approval QC Inspector		

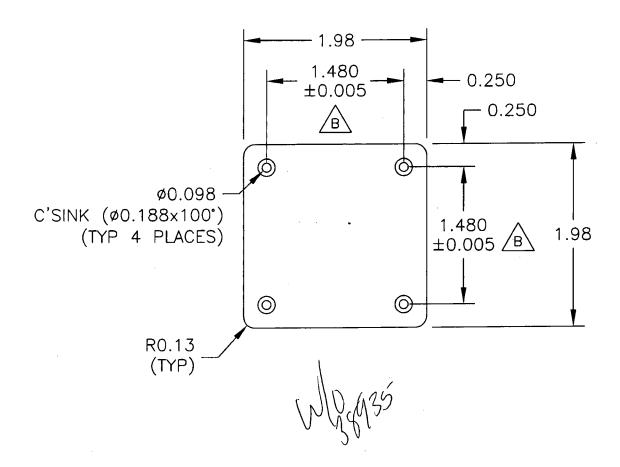
NOTE: Date & initial all entries

QA: N/C Closed: ____ Date: ___



DESIGN	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
CHECKED	APPROVED	DRAWING NO.	REV. C
A	-#	D3278	SHEET 3 OF 3
DATE	·	TITLE	SCALE
07.07.24		SUPPORT ASSEMBLY	1:1





D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL

 (REF. DART SPEC. M-DELRIN-B0.125×2.000) OR

 DELRIN II 150E OR ACETRON GP ACETAL

 (REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Dart Aerospace Ltd

W/O:		WORK ORDER C	HANGES				
DATE	STEP	, PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		_					
Part No	•	PAR #: Fault Category:	NCR: Yes	No DQ	A:	Date:	
		·	ΟΔ.	N/C Close	q٠	Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B	Verification	Approval	Approval			
DATE STE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector		

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 38935
Description: SPICER	Part Number: D3278-3
Inspection Dwg:03378-3 Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

		<u> </u>				
Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejec	Method of inspection	
8PD, Q	4.004001	,099	¥			
.350	14- 010	026.	*	1		
02G,	4- 010	, DS0	<u> </u>		<u> </u>	
1.480	1/2 .010	1.479	يلا		<u> </u>	<u> </u>
1480	4- ao		X			
1.98	400	1.995	8			
1.98	4630	1.995	X	<u> </u>		
				<u> </u>		
					ļ	
					-	
				-		
				ļ		
						-
					. [

,						
Messured by:	B	Audited by:	7	Prototype Approvai:	L	
Date:	8-5-2	Date:	06/05/05	Date:		14
3- 5-	1 8:					

Rev	Date	Change	Revised by	Approved
A.		New Issue	KJ/JLM	

